

NCR-19 7646



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400213-4
Job Sheet 189162



Part No: RBT400213-4

Job Qty: 20 pcs

Part Name: Right Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 2/22/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT400213 Rev F IPP Rev A 17.11.27 New issue DP Verify DD/IPP Rev B 18.03.08 DWG update Rev.
F DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	NV5000 - 1	20		2/22/19	0.50	10.00	NV5000 - 1		PJ 19-06-19
		pcs					NV5000 - 2		
120	QC 2	20		2/22/19	0.00	0.00	QC 2 - 1		PJ 19-06-19
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S192031



Part: RBT400213-4

Job No: 189162

Serial No/Batch: S192031

Revision: F

Inspector:

Exp Date:

Instructions:

Date: 06/19/19

130 QC 8	20 pcs	2/22/19	0.00	0.00	QC 2 - 63							
					QC 2 - 8							
					QC 8 - 12							
					QC 8 - 14	JUL 19/06/19						
					QC 8 - 17							
					QC 8 - 20							
					QC 8 - 25							
					QC 8 - 3							
					QC 8 - 32							
					QC 8 - 33							
					QC 8 - 35							
					QC 8 - 38							
					QC 8 - 39							
					QC 8 - 4							
					QC 8 - 44							
					QC 8 - 45							
					QC 8 - 49							
					QC 8 - 58							
					QC 8 - 8							
					QC 8 - 9							
					QC 8 - 68							
QC 8 - 67												
QC 8 - 1 (A)												
140 QC 5	20 pcs	2/22/19	0.00	0.00	QC 5 - 10							
					QC 5 - 12							
					QC 5 - 17							
					QC 5 - 18							
					QC 5 - 19							
					QC 5 - 22							
					QC 5 - 24							
					QC 5 - 3							
					QC 5 - 38							
					QC 5 - 42							
					QC 5 - 43							
					QC 5 - 49							
					QC 5 - 51							
					QC 5 - 58							
					QC 5 - 68							
					QC 5 - 9							
					QC 5 - 50							
					QC 5 - 30							
					150 Outsource - 4 - Anodize	20 pcs	2/22/19			ATG001-VC	15	JUL 2019-06-21
					160 Packaging 2-1 - Recelve - B4B	20 pcs	2/22/19	0.00	0.00	Packaging 2 - 1 - B4B		JUL 12 2019
										Packaging 2 - 2 - B4B		
Packaging 2 - 3 - B4B												
Packaging 2 - 5 - B4B												
Packaging 2 - 4 - B4B												
Packaging 2 - 6 - B4B												
Packaging 2 - 7 - B4B												
Packaging 2 - 8 - B4B												
Packaging 2 - 9 - B4B												
Packaging 2 - 10 - B4B												
Packaging 2 - 11 - B4B												
Packaging 2 - 12 - B4B												
Packaging 2 - 13 - B4B												
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				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	20 pcs	2/22/19	0.00 0.00	QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
180 Packaging 3-1 - Stock - B4B	20 pcs	2/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	

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				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	2/22/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	

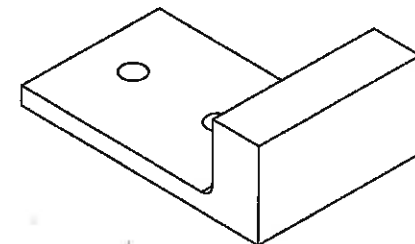
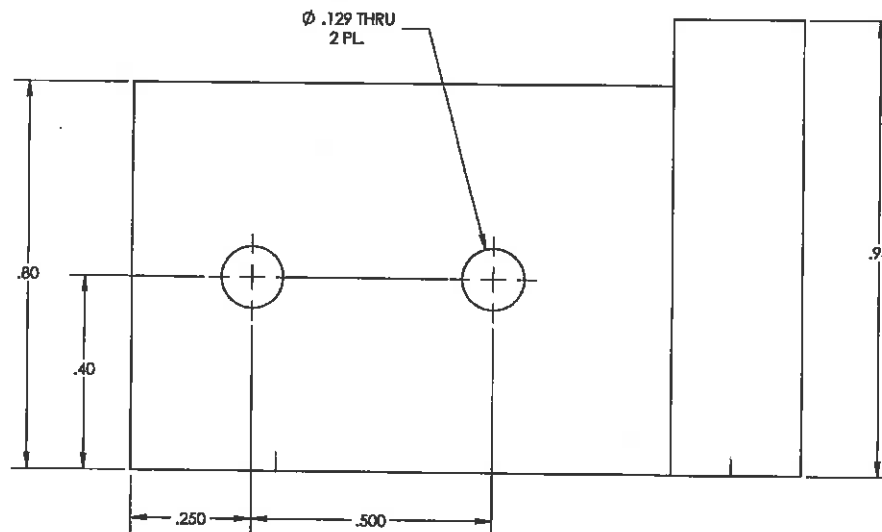
Part Op 110 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FC321 FOLIO REV: AA DWG
 Descriptions: REV: F Engrave part number and batch number And T/N number 2-Deburr
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG : PO 43814 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required
 160 - (Receive & Inspect for Damage & Mat'l Certs)
 170 - (QC6- All purchased or subcontracted products)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.625X01.500	6061-T6 Bar .625 X 1.50	2.6000 ft (.13 ea)	110-NV5000 - 1	5158 597
cut at 64 = 5 pcs				
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-NV5000 - 1	M6061T6B0.625X01.500	3	3	0
Part Specifications				
Specifications could not be found.				

MAT
used
2.855

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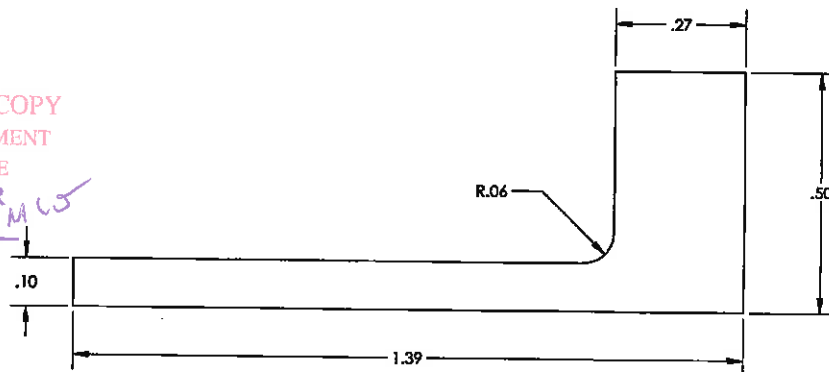
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	TEMPLATE UPDATED, TOLERANCES CHANGED ON DIMENSIONS .937 / .800 / .270 / .500 / .400 TO X.XX	17-797	17.12.21	VM	ML



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WITHOUT NOTICE

WORK ORDER

NO. 183162 M15
19-01-21



RBT400213-4 RIGHT CLAMP

- NOTES:
- 1) MATERIAL: 6061-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: RED ANODIZE
 - 4) SPEC: MIL-A-8625, TYPE II, CLASS 2; WATER SEALANT
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

DART AEROSPACE		Markham, Ontario, Canada	
RIGHT CLAMP			
PART NO. RBT400213-4		REV F	
TOOL NO. RBT400213		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET TO AS TO 1/16" UNLESS DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY: VM 12/21/2017		TOLERANCES: X .005 X .01 X .03	
DRAWN BY: VM 01/02/2018		FRACTIONS: ± 1/8 ANGLES: ± 5°	
CHECKED BY: VM 01/02/2018		SURFACE ROUGHNESS	
MFG REVIEW BY: DD 01/02/2018		SCALE: NTS	
APPROVED BY: ML 01/30/2018		SHEET 6 OF 7	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043814



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043814

PO Date: 6/21/19

Due Date: 7/8/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-07-08

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186607	C2-2-1	Side Plate -Issue P/O: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	7/8/19	7 pcs	0 pcs	7 pcs	\$6.38/pcs	\$44.66
2	189161	RBT400213-3	Left Clamp (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	7/8/19	20 pcs	0 pcs	20 pcs	\$6.38/pcs	\$127.60
3	189162	RBT400213-4	Right Clamp (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	7/8/19	20 pcs 17 K4	0 pcs	20 pcs 17 K4	\$6.38/pcs	\$127.60 108.46



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PURCHASE ORDER

POHB043814



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	196688	RBW109-3101-58-1-7	Handle (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLUE, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	7/8/19	19 pcs	0 pcs	19 pcs	\$8.19/pcs	\$155.61
5	186720-A	RBT18520-1	Lift Device Frame -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	7/8/19	1 pcs	0 pcs	1 pcs	\$6.38/pcs	\$6.38
Grand Total:											\$461.85

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/8/19 11:45 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918169

Date: 09-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 7 each	Part: C2-2-1 ✓ Side Plate Anodize per MIL-A-8625F, Type II, Class2, Black, Water Sealant, .0004-.0010" (4 - 1 mils). Job: 25363 PO: POHB043814 ✓		Rev: 10 Line: 1
✓ 20 each	Part: RBT400213-3 ✓ Left Clamp Anodize per MIL-A-8625F, Type II, Class2, Red, Water Sealant, .0004-.0010" (4 - 1 mils). Job: 25364 PO: POHB043814 ✓		Rev: F Line: 2
✓ 17 each	Part: RBT400213-4 ✓ Right Clamp Anodize per MIL-A-8625F, Type II, Class2, Red, Water Sealant, .0004-.0010" (4 - 1 mils). Job: 25365 PO: POHB043814 ✓		Rev: F Line: 3
✓ 19 ea	Part: RBW109-3101-58-1-7 ✓ Handle Anodize per MIL-A-8625F, Type II, Class2, Blue, .0004-.0010" (4 - 1 mils). Water Sealant Job: 25366 PO: POHB043814 ✓		Rev: 3 Line: 4
✓ 1 ea	Part: RBT18520-16 ✓ Lift Device Frame Black Anodize per MIL-A-8625F, Type II, Class2, .0004-.0010" (4 - 1 mils), Water Sealant		Rev: 11

MADE IN CANADA

RECEIVED
JUL 11 2019
DART AEROSPACE LTD

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RECEIVED

JUL 11 2019

DART AEROSPACE LTD.

Made in Canada.



A.T.G. Industries Inc.
780 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918169

Date: 09-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Job: 25367 PO: POHB043814 ✓		
	Line: 5		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>7/1/19</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

Entered:

Date:

Oct-30/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7646

Route update only

Job: <u>199 CG2</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier Quality ☐					
Part No. <u>RBT 400A3-4</u>									
Date : <u>19-06-19</u>	Sequence #: <u>0043</u>		QTY Affected : <u>3</u> <u>17</u>				DAS 55 9-89 <u>19-6-19</u>		
Description Work Order Deviation				Disposition				Completed By <u>PS</u> <u>19-06-19</u>	
<u>PCS moved in jaws</u>				<u>Nothing</u> <u>SCRAP</u> <u>[Signature]</u>				Lead hand / Supervisor <u>[Signature]</u> <u>19/06/19</u>	
								QC / QA Coordinator DAS 55 9-89 <u>19-6-19</u>	
Root Cause		FAULT CATEGORY							
Operator ☐		☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge		☒ Positioned Wrong			
Manufacturing Process ☐		☐ Bending	☐ Misaligned/off center	☐ Folio/Program		☐ Outside Tolerance			
Equip/Tooling ☒		☐ Crushing	☐ BOM/Route	☐ Grain Direction		☐ Drawing			
Handling/Presservation ☐		☐ Cracks	☐ Broken/Damage/Defect	☐ Weld		☐ Finish			
Material ☐		☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled		☐ Part Lost/Missing			
Product Improvement ☐		☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence		☐ Misread			
Process Improvement ☐		☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up					
Human Factors ☐		Other/Details:							